

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019716**Date Inspected:** 28-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

**OBG 14EAST**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 002 located at PCMK SEG3019AA. ZPMC QC Mr. Guo Xing Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2774.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066471 performing the Flux Cored Arc Welding process on weld 104 located at PCMK SEG3019G. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068501 performing the Flux Cored Arc Welding process on weld 206 located at PCMK SEG3019L. ZPMC QC Mr. Xie Ming Feng was monitoring this

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070006 performing the Shielded Metal Arc Welding process on weld 192 located at PCMK SEG3019E-2. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-Fcm-1.

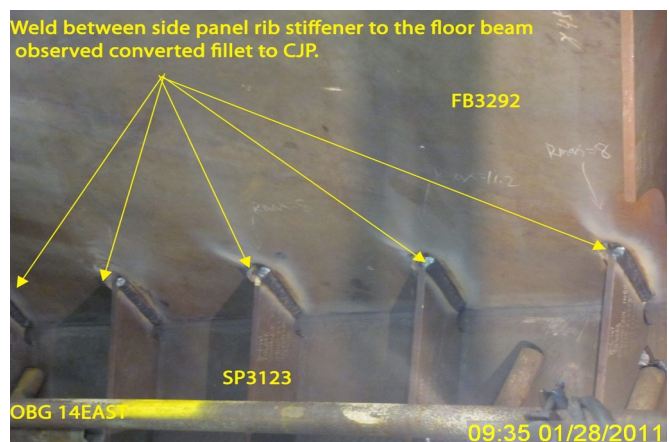
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066471 performing the Flux Cored Arc Welding process on weld 157 located at PCMK SEG3019J. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing the Flux Cored Arc Welding process on weld 003 located at PCMK SEG3019BB. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 003 located at PCMK SEG3019U. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

During the random visual inspection this QA Inspector observed ZPMC had change weld detail as fillet to CJP, for the weld between side panel rib stiffeners to floor beam (FB3293), Weld number identified as SEG3019G-100/101, 104/103, 108/109, 112/113, 116/117, 120/121, 124/125, 128/129, 132/133, 136/137, 140/141, 144/145, 148/149, 152/153, 156/157, 160/161, 168/169, 172/173, 176/177. This weld detail change as per approved B-JC116R0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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